

Work Order ID 165250

Thursday, August 17, 2017 10:37:31 AM

165250

Page 1

Item ID: D3913-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib
Start Date: 8/17/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS Date: AUG 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3913	D								
100		0.00							
100									
Large Fab	Memo	0.76							
Large Fab	1- Cut tube as per dwg D3913 2- Drill hole as per dwg using DT9915 ***one side only*** 3- remove identification marks and deburr								
110	QC6- All purchased or subcontracted products	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA004</u>	0.00							
120									
Packaging	Memo	0.04							
Packaging	LOCATION: WA004								

4x D.M.L 2017-8-22438
9-89
AUG 24 20174x D.M.L 2017-8-24

Work Order ID 165250

Thursday, August 17, 2017 10:37:31 AM

165250

Page 2

Item ID: D3913-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Rib
Start Date: 8/17/2017 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 8/18/2017 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.40							
Quality Control									

AUG 25 2017

DAS
21
9-89

Picklist Print

Thursday, August 17, 2017 10:37:34 AM

Page 1

Work Order ID: 165250

165250

Parent Item: D3913-1

D3913-1

Parent Item Name: Rib

Start Date: 8/17/2017

Required Date: 8/18/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
add drill one side only DD 10.04.12 verified by:EC IPP Rev:C 11.01.18
chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

100

f

627.1895

8

33.68421

M304TS0 750W 049

**

P.M.L 2017-8-22

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

WA004

627.189474

137625

34

M137401

0.689474

M137625

285

M137824

2

M137934

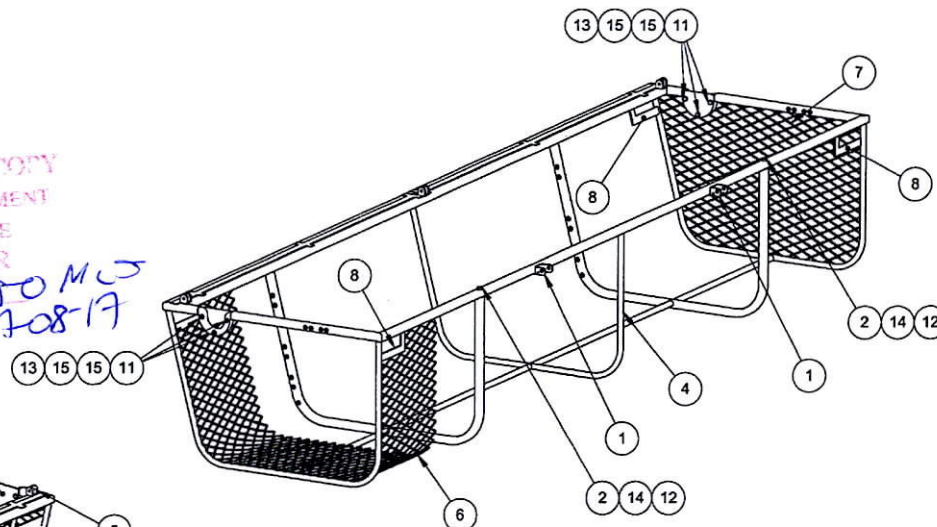
39.5

M138160

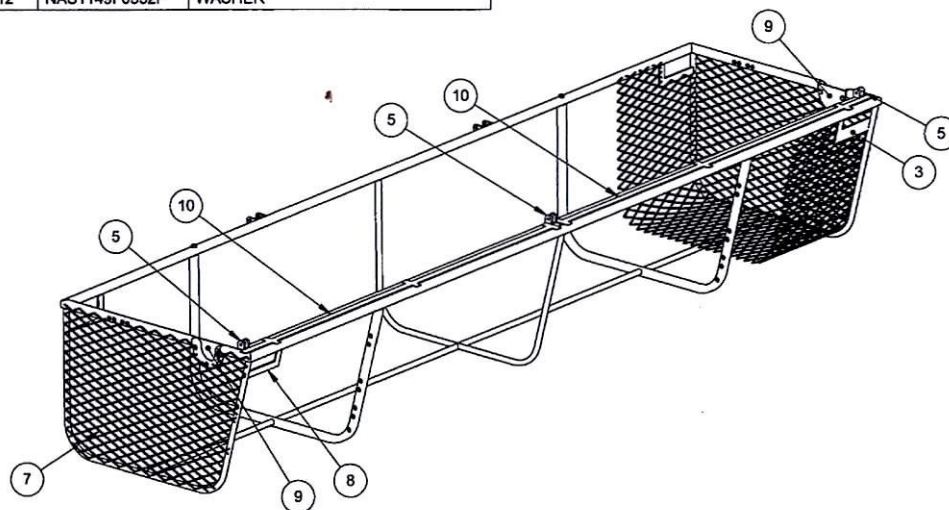
300

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165250 M.C.
170817



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



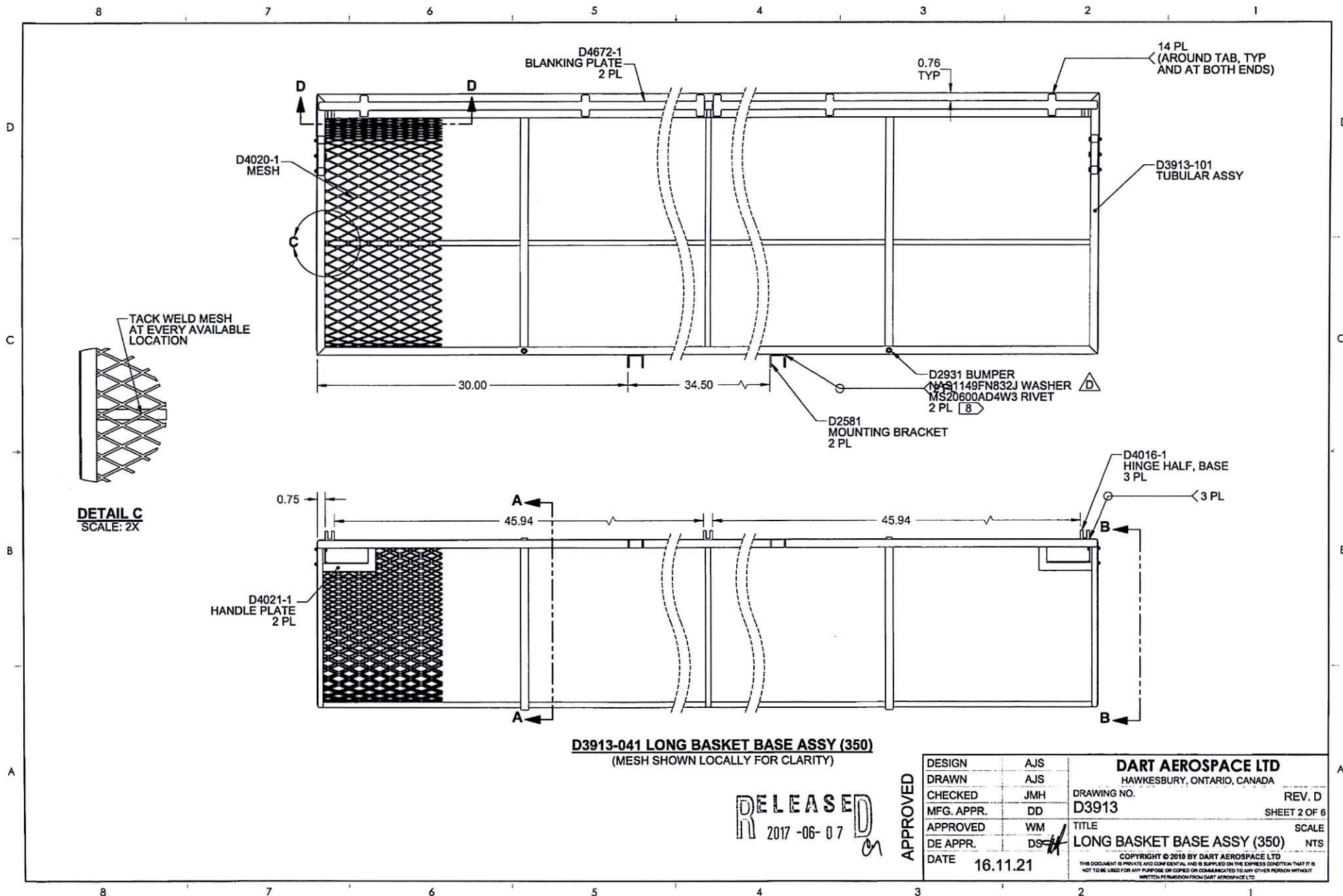
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

D	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN960JD8, UPDATED NOTE 6, ADDED NOTE 11. SHEET 3 ADDED VIEW E-E. (PAR15-418)	AJS	16.11.21
C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PAR12-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	LONG BASKET BASE ASSY (350)	NTS
DATE	16.11.21	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-06-07
EN 17-580

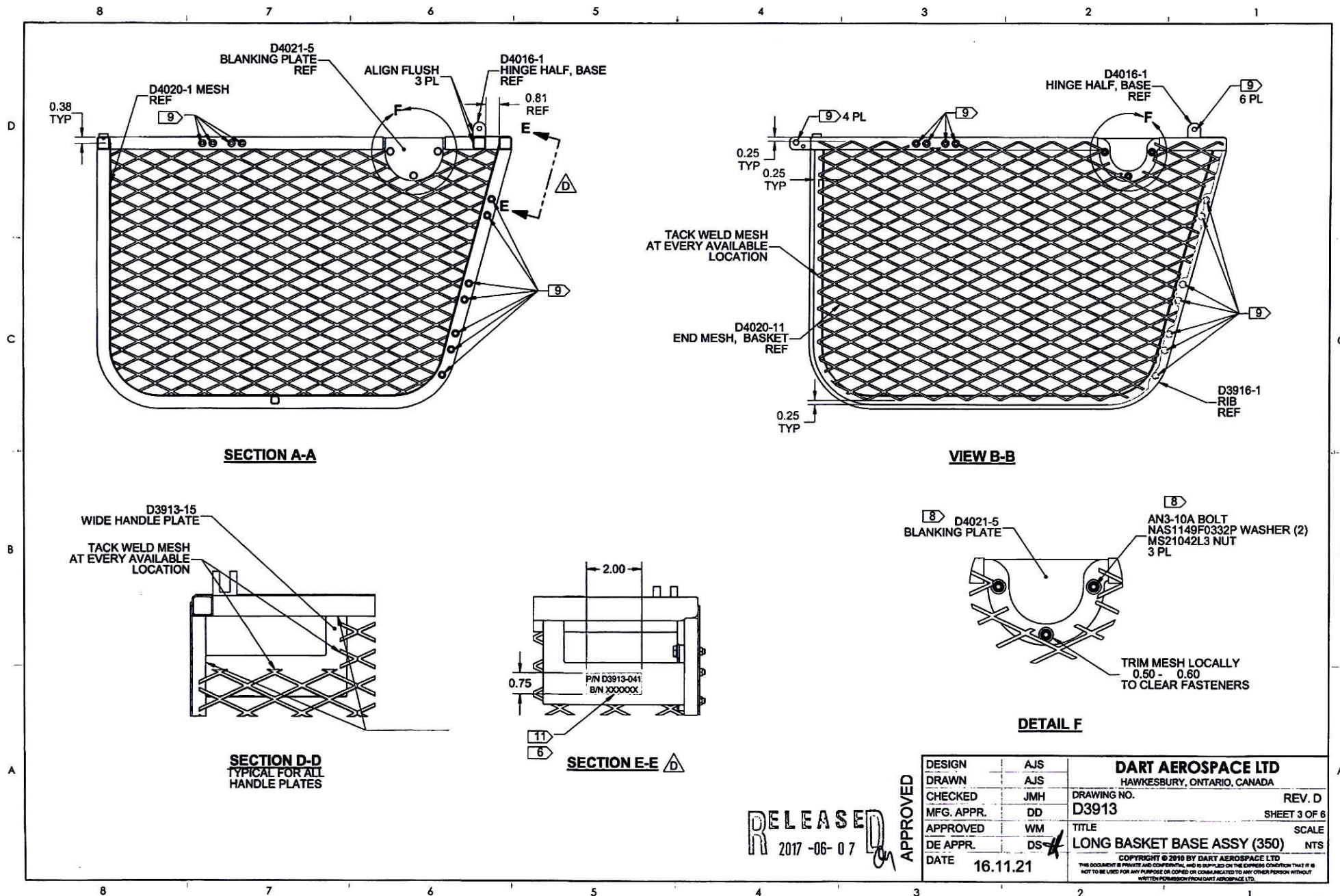
APPROVED



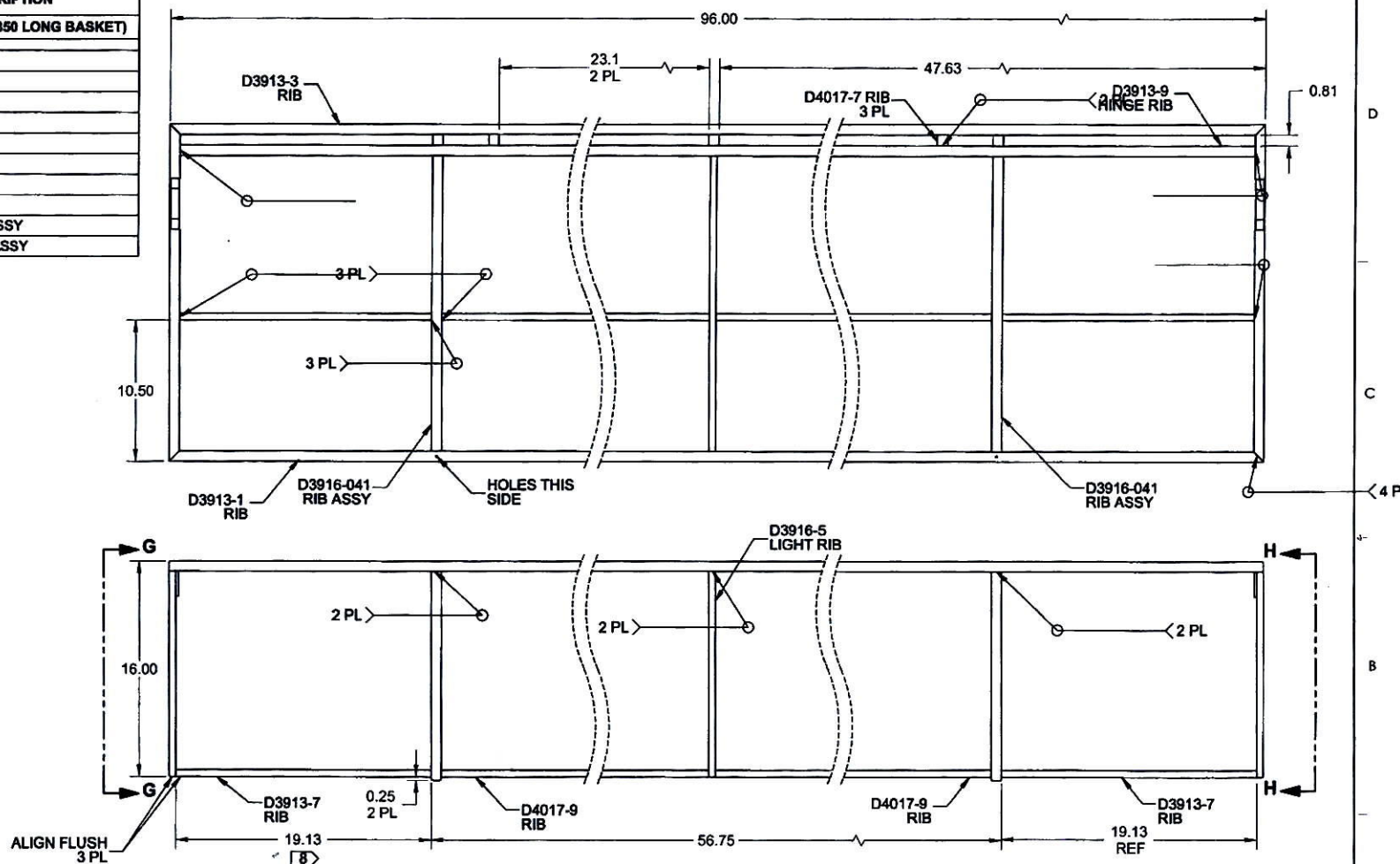
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2017-06-07

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



D3913-101 TUBULAR ASSY (350 LONG BASKET)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.65 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

RELEASED
2017-06-07

APPROVED

DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.21

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3913

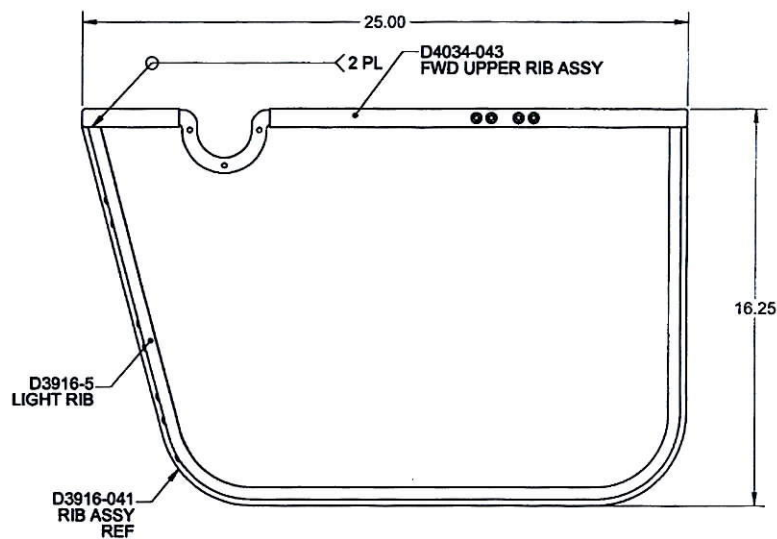
REV. D

SHEET 4 OF 6

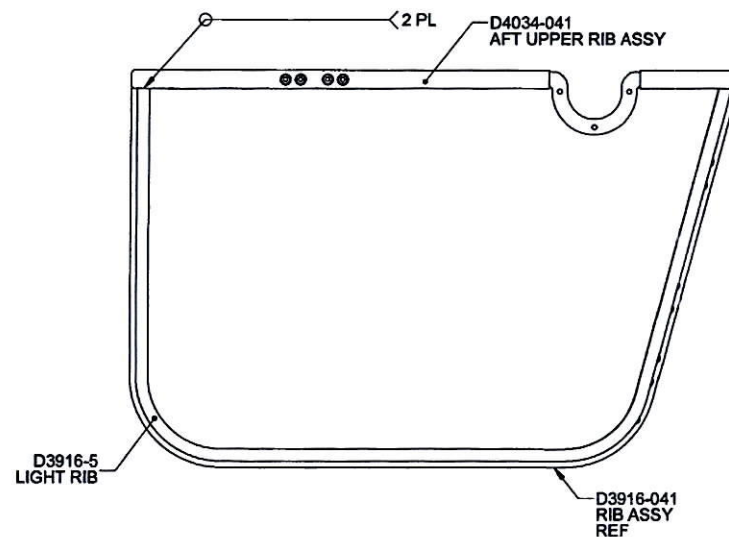
TITLE
LONG BASKET BASE ASSY (350)

SCALE
NTS

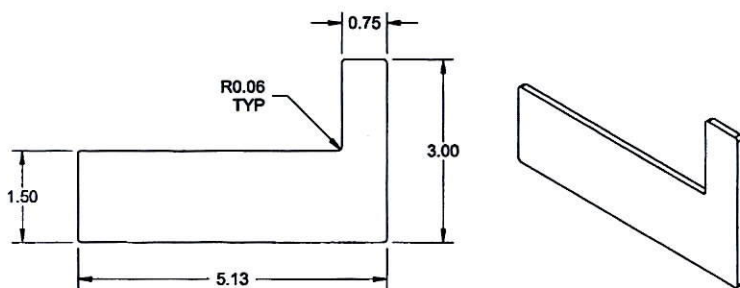
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SECTION G-G
SCALE 2X



SECTION H-H
SCALE 2X



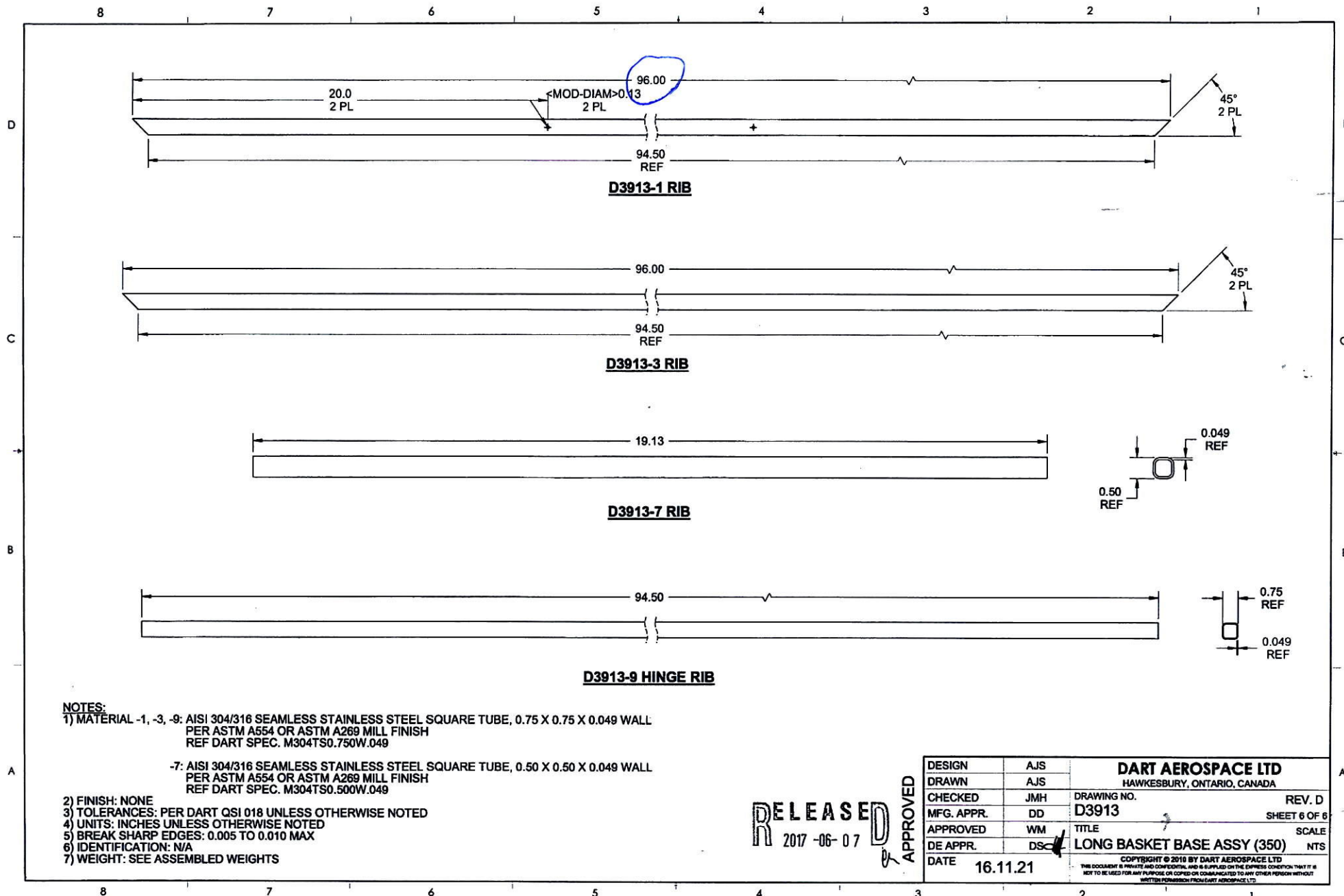
D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.125 THICK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

RELEASED
2017-06-07
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JMH	DRAWING NO.	REV. D
MFG. APPR.	DD	D3913	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DE	LONG BASKET BASE ASSY (350)	NTS
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Purchase Order Receipt Listing

Wednesday, May 24, 2017 3:29:05 PM

All amounts are calculated in domestic currency.

Page 1 of 1

All Vendors PO ID PO36329 Receipt Dates from 5/23/2017 to 5/23/2017 All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MET002	Metaux Solutions								
PO36329	1		M304TS0.750W.049 f		5/24/2017	5/23/2017	500.0000	\$2.78	0.0000	0	\$1,390.80
CAD	No		304 SQ Tube 45 f		500.0000	PLOU01		\$1,390.80	0.0000	0	
			.75x.75x.049W								
			m137625								
	3		MSTEEL-A2- 1.275 f		5/24/2017	5/23/2017	24.0000	\$9.06	0.0000	0	\$217.40
	No		B0.500X1.250 f		24.0000	PLOU01		\$217.40	0.0000	0	
			AISI A2 TOOL								
			STEEL BAR, 0.500								
			X 1.250								
			m137625								
	4		71401-45		5/24/2017	5/23/2017	1.0000	\$0.00	0.0000	0	\$0.00
	No		PROCUREMENT		1.0000	PLOU01		\$0.00	0.0000	0	
			QUALITY								
			CLAUSES								
			m137625								

Shipping Order

19/05/2017

METAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7
Tel.: 450 641-3330

Order : 125634
Reference : 36329
Ship : PICK UP / PICK UP

Customer: 6323336

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Ship To

Same

Tel.: 1 613 632-3336

Item No.	Description	Qty	Qty. Delivered	B/O Qty
SSQT34340494	***** FACTURER E-MAIL ***** SUPER IMPORTANT SUR LE PACKING SLIP INSCRIRE LES HEAT N 304 SQ TUBE .750 X .049 WALL 25 X 20' **** HT: TBG113301	500	500	€
TP12A2	A-2 PLATE TFA 1/2" THICK ht# 59498 2 X 1.25" -0+0 X 144" R/L	56	56	€

SHIP JOURNEY COLLECT
HP

817-5-24.

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36329

Purchase Order Date 5/16/2017 1:03:43 PM
PO Print Date 5/16/2017

Page Number 1 of 2

Order From :

VC-MET002

Ship To : DART AEROSPACE LTD

METAUX SOLUTIONS
2625 BOUL JACQUES-CARTIER EST
LONGUEUIL, QC J4N 1L7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 16 2017

Contact Name

Vendor Phone 800 558 8858

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

Journey Freight collect

FOB

Destination-Collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	----------------

1	M304TS0.750W.049	304 SQ Tube .75x.75x.049W	5/23/2017		500.00	\$3.80	\$1,900.00
			Yes 5/23/2017		f		

MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING
AS PER ASTM A554 MILL FINISH
OR
AS PER ASTM A269 MILL FINISH

Line Total: \$1,900.00

3	MSTEEL-A2-B0.500X1.250	AISI A2 TOOL STEEL BAR, 0.500 X 1.250	5/23/2017		24.00	\$12.38	\$297.00
			Yes 5/23/2017		f		

MATERIAL: AISI A2 TOOL STEEL, ANNELED CONDITION
AS PER A681

NOTE: TOLERANCE -0+0" AS PER QUOTATION #16619
CUT AT 1.25"

SP17-5-24

Line Total: \$297.00

Note:

5/16/2017

檢驗證明書
INSPECTION CERTIFICATE

524彰化縣溪州鄉中山路四段270號
No.270, Sec.4, Jungshan Rd., Shijou Shiang,
Chang-Hwa, Taiwan, R.O.C
http://www.ycinox.com
TEL : +886-4-8899666 FAX : +886-4-8899770



客戶名稱 Customer	客戶編號 Customer No.	FCA027	證明書編號 Certificate No.	170110P0122
產品名稱 Production	商業發票號碼 Commercial Invoice No.	J16120312	證明書日期 Date of Issue	2017/01/10
規範名稱 Specification	客戶採購單號 PO No.	P006792	訂單編號 Order No.	EP16110139-1
鋼種 Steel Grade	提貨單編號 Weight No.	C17010081	P.I.號碼 P.I.NO.	PI 1611-087
產品名稱 STAINLESS STEEL WELDED TUBE				
規範名稱 ASTM A554-16				
鋼種 MT-304				

		產品規格 Product Description			化學成份(%) Chemical Composition										拉伸試驗 Tension Test			'01 硬度試驗
項目 Item No.	爐號 Heat No.	尺寸 Dimension	數量 Quantity Pcs	表面 Finish	C	Si	Mn	P	S	Ni	Cr	伸長 0.2%Y.S.	抗拉 T.S.	伸長率 E.L.	HRB			
					X10 ⁻³	X10 ⁻³	X10 ⁻³	X10 ⁻³	X10 ⁻³	X10 ⁻³	X10 ⁻³	MPa	%					
Specification					Min.													
				Max.	80	100	200	45		30	1100	2000						
1	TBG113301	3/4"(19mm)x3/4"(19mm) x 0.049"(1.25mm) x 20FT	60															
2	TBG091286	2 1/2"(63.5mm)x2 1/2"(63.5mm) x 1/4" x 20FT	5	MILL	44	47	89	35	4	806	1820	312	660	52	85			
3	TBG092176	2"(50.8mm)x2"(50.8mm) x 1/4" x 20FT	13	MILL	19	28	141	26	3	800	1828	297	620	53	84			
4	TBG121892	3"(76.2mm)x3"(76.2mm) x 0.12"(3.05mm) x 20FT	23	MILL	24	31	139	28	8	804	1821	305	649	52	84			
5	TBG122730	3"(76.2mm)x3"(76.2mm) x 1/4" x 20FT	23	MILL	24	44	154	29	1	800	1811	308	690	50	88			
6	TBG113722	4"(101.6mm)x4"(101.6mm) x 0.12"(3.05mm) x 20FT	23	MILL	18	31	137	33	7	802	1827	298	626	53	86			
7	TBG113712	4"(101.6mm)x4"(101.6mm) x 0.180"(4.57mm) x 20FT	13	MILL	15	37	104	24	3	804	1837	289	651	52	83			
8	TBG113689	4"(101.6mm)x4"(101.6mm) x 1/4" x 20FT	25	MILL	19	31	138	35	7	804	1827	303	628	53	87			
9	TBG122118	1 1/4"(31.8mm)x1 1/4"(31.8mm) x 0.12"(3.05mm) x 20FT	50	MILL	42	49	89	34	2	810	1813	301	659	53	87			
10	TBG113247	2"(50.8mm)x2"(50.8mm) x 0.12"(3.05mm) x 20FT	25	MILL	54	48	134	35	2	813	1811	274	644	55	84			
11	TBG113248	2"(50.8mm)x2"(50.8mm) x 0.12"(3.05mm) x 20FT	25	MILL	44	41	89	39	6	801	1808	280	644	53	84			
TOTAL:			275															
附註 Remark																		

附註 Remark

附註 Note

This certificate complies to 3.1/EN 10204:2004.

*01= Hardness Test
*Gauge Length: 50mm

Visual Inspection (Surface) and Dimension Check : OK

1MPa=1N/mm²≈10bar=145psi=10.2kgf/cm²

Surveyor By

N/A

茲證明本文所列產品，均依材料標準製造及試驗，並符合標準之要求，與無輻射污染。
We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification. The material described above has been found free of radiation by raw material supplier.

1.ISO 9001:2008 (No.01 100 056299)
2.PED / AD2000 (No.01 202 TWWQ-05 0105)
3.ISO 14001:2004 (No.01 104 822 096385)
4.OHSAS 18001:2007 (No.01 113 822 096385)

Manager of Quality Assurance Department

Jie Yi Chen

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304750.75CW.049

PO / BATCH NO. 2036329/M137625

DATE: MAY 25 2017

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 500'
 QUANTITY INSPECTED: 500'
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .049
 THICKNESS RECEIVED: .045
 SHEET SIZE ORDERED: NA
 SHEET SIZE RECEIVED: NA

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y (N)	
CORRECT FINISH	(Y) N	
CORROSION	Y (N)	
CORRECT GRAIN DIRECTION	(Y) N	
CORRECT MATERIAL PER M-DRAWING	(Y) N	ASTM A554
CORRECT THICKNESS	(Y) N	
PHOTO REQUIRED	Y (N)	
CORRECT REF # TO LINK CERT	(Y) N	HT # TBG113301
CORRECT MATERIAL IDENTIFICATION	(Y) N	
CORRECT M# ON THE MATERIAL	(Y) N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y (N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y (N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW				
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>CB</u>		SIGNED OFF BY: _____	
DATE: <u>MAY 25 2017</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in